

82873

Page 1

Setup Start *NS1*

Stop ***NS2***

*** 1 ***

*** 1 ***

Run Start *NR1*

Stop *NR2*

Date:

[illegible]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82873***82873***

Page 2

Tuesday, April 10, 2012 2:28:37 PM

Item ID: D4030-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Long Basket Assembly (350)
Start Date: 4/10/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/20/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ 12/04/27
MK
12-04-27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, April 10, 2012 2:28:41 PM

Page 1

Work Order ID: 82873

82873

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/10/2012

Required Date: 4/20/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC IPP Rev D 12.03.27 per NCR12-1239 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4086-200		Manufactured	No				Each	1.0000		1			
D4086-200									**	82827	JB		
Placard, Max Load													

Location Loc Qty Loc Code

ST122 1
72051 1

D2530		Manufactured	No			100	Each	11.0000	1	1	✓		
D2530									**	JB			
Handle Weldment													

Location Loc Qty Loc Code

ST506 11
77030 1
82150 10

D2535		Manufactured	No			100	Each	24.0000	2	2	✓		
D2535									**	JB			
Spring													

Location Loc Qty Loc Code

ST504 24
77488 24

D2537		Manufactured	No			100	Each	14.0000	2	2	✓		
D2537									**	JB	12/04/25		
Bushing													

Location Loc Qty Loc Code

ST504 14
77055 14

82896

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Tuesday, April 10, 2012 2:28:41 PM

Work Order ID: 82873

82873

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/10/2012

Required Date: 4/20/2012

Start Qty: 1.00

Required Qty: 1.00

D3913-041	Manufactured	No	100	Each	0.0000	1	1	
D3913-041						**	1	BL 12-4-26.
Long Basket Base Assembly, 350								
D3914-041	Manufactured	No	100	Each	0.0000	1	1	
D3914-041						**	1	BL 12-4-26.
Long Basket Lid Assembly (350)								
D3917-3	Manufactured	No	100	Each	67.0000	6	6	✓
D3917-3						**		JB
Washer								

Location	Loc Qty	Loc Code
ST070	67	
76956	4	
80598	1	
81205	62	81205

D3953-3	Manufactured	No	100	Each	24.0000	2	2	
D3953-3						**		JB
Gas Spring Stud, Lid								

Location	Loc Qty	Loc Code
ST075	24	
78042	8	
82044	16	82044

D3953-7	Manufactured	No	100	Each	34.0000	2	2	✓
D3953-7						**		JB 12/04/25
Spring Spacer								

Location	Loc Qty	Loc Code
ST075	34	
82045	34	82045

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Tuesday, April 10, 2012 2:28:41 PM

Page 3

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82873

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/10/2012

Required Date: 4/20/2012

Start Qty: 1.00

Required Qty: 1.00

D3953-9 Manufactured No

100 Each

51.0000

2 2

D3953-9

Gas Spring Washer

**

Location

Loc Qty

Loc Code

ST075

51

82035

51

D3953-17

Manufactured No

100 Each

25.0000

2 2

D3953-17

Gas Spring Spacer

**

Location

Loc Qty

Loc Code

ST075

25

81206

24

81454

1

D3953-19

Manufactured No

100 Each

5.0000

1 1

D3953-19

Gas Spring Bracket

**

Location

Loc Qty

Loc Code

ST075

5

75227

5

D3953-21

Manufactured No

100 Each

22.0000

1 1

D3953-21

Gas Spring Bracket

**

Location

Loc Qty

Loc Code

ST075

22

81207

16

81456

6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/10/2012

Required Date: 4/20/2012

Start Qty: 1.00

Required Qty: 1.00

D3969-3 Manufactured No

100

Each

25.0000

1

1

✓

D3969-3

Spring (Basket Lid)

**

JB

Location

Loc Qty

Loc Code

ST272

25

64285

1

73515

8

81887

16

73515

AN3-14A Purchased No

100

Each

60.0000

4

4

✓

AN3-14A

Bolt

**

JB

Location

Loc Qty

Loc Code

ST352

60

119328

60

119328

AN3-16A Purchased No

100

Each

117.0000

2

2

✓

AN3-16A

Bolt

**

119

JB

Location

Loc Qty

Loc Code

ST352

117

117441

49

118628

18

120986

50

1x118628

1x120986

AN5-17A Purchased No

100

Each

140.0000

4

4

✓

AN5-17A

Bolt

**

JB

12/04/25

Location

Loc Qty

Loc Code

338

98

121181

98

121181

ST338

42

117872

42

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Tuesday, April 10, 2012 2:28:41 PM

Work Order ID: 82873

82873

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/10/2012

Required Date: 4/20/2012

Start Qty: 1.00

Required Qty: 1.00

AN4-12 Purchased No

100 Each 62.0000 3 3 ✓

AN4-12

Bolt

**

JB

Location

Loc Qty

Loc Code

ST357

62

118626

1

119775

25

120986

36

120986

AN310-4 Purchased No

100 Each 73.0000 3 3 ✓

AN310-4

NUT

**

JB

Location

Loc Qty

Loc Code

ST344

73

120124

1

120518

25

121011

22

121162

25

121162

AN310C4 Purchased No

100 Each 69.0000 2 2 ✓

AN310C4

Nut

**

JB

12/04/25

Location

Loc Qty

Loc Code

ST344

69

120360

30

121166

39

121166

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 82873

82873

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/10/2012

Required Date: 4/20/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

100

Each

2,198.000

6

6 ✓

MS21042L3

**

121349 JB

Nut

Location

Loc Qty

Loc Code

ST300

2198

117441

16

117885

32

118451

5

118927

3

119017

1976

119075

166

MS21042L5

Purchased

No

100

Each

1,446.000

4

4 ✓

MS21042L5

**

JB

Nut

Location

Loc Qty

Loc Code

ST300

1446

116105

5

116548

43

117611

42

119109

1356

119109

MS24665-151

Purchased

No

100

Each

278.0000

3

3 ✓

MS24665-151

**

JB 12/04/25

Cotter Pin

Location

Loc Qty

Loc Code

ST309

278

17566

278

17566

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 7

Tuesday, April 10, 2012 2:28:42 PM

Work Order ID: 82873

82873

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/10/2012

Required Date: 4/20/2012

Start Qty: 1.00

Required Qty: 1.00

MS24665-300

Purchased

No

100

Each

191.0000

2

2

✓

MS24665-300

Cotter Pin

**

JB

Location

Loc Qty

Loc Code

GA

187

118234

187

ST309

4

116823

4

118234

NAS1149F0432P

Purchased

No

100

Each

310.0000

6

6

✓

NAS1149F0432P

Washer

**

JB

Location

Loc Qty

Loc Code

ST275

310

121166

110

121255

200

121255

NAS1149F0563P

Purchased

No

100

Each

57.0000

4

4

✓

NAS1149F0563P

Washer

**

JB

12/04/25

Location

Loc Qty

Loc Code

ST275

57

117735

57

117735

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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82873

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/10/2012

Required Date: 4/20/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

100

Each

690.0000

8

8

✓

NAS1149F0332P

WASHER

**

JB

Location

Loc Qty

Loc Code

ST275

690

117735

37

119225

10

120910

198

120986

200

121166

42

121259

200

17317

3

120910

NAS1149C0432R

Purchased

No

100

Each

5,000.000

2

2

✓

NAS1149C0432R

Washer

**

JP

12/04/25

Location

Loc Qty

Loc Code

ST297

2000

117291

1000

119124

1000

ST298

3000

121255

3000

117291

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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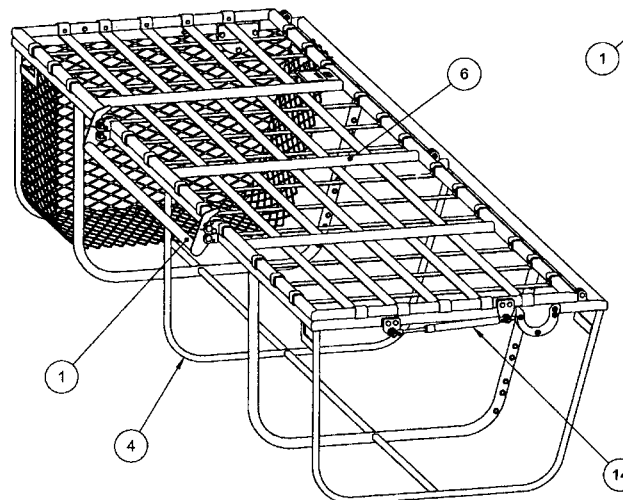
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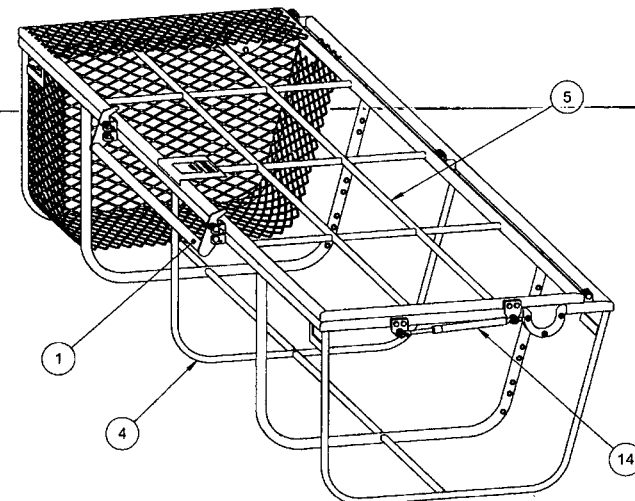
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	1	D3914-041	LONG BASKET, LID ASSY. (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82873

R12-04-10



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12 G
ECN 10-596

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D6-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>AJS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>JP</i>		
CHECKED	<i>JP</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>JP</i>	D4030	SHEET 1 OF 3
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	LONG BASKET ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Dart Aerospace Ltd

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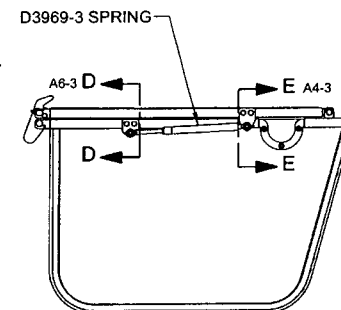
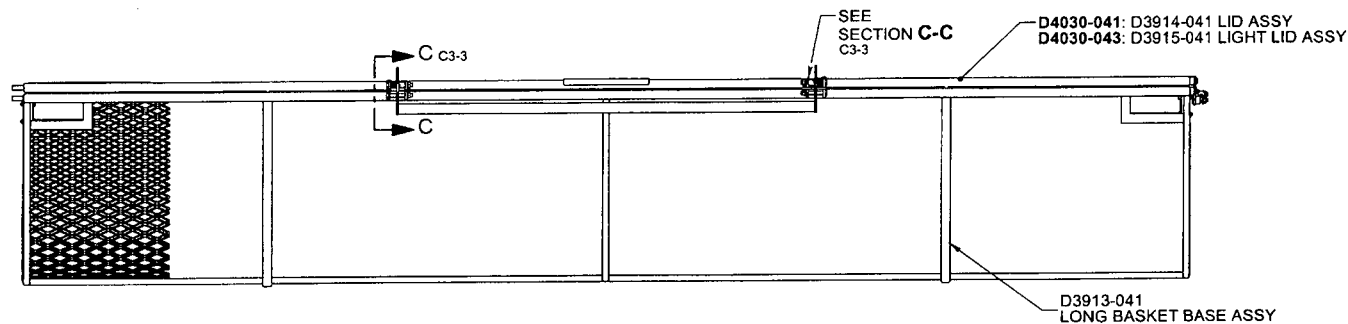
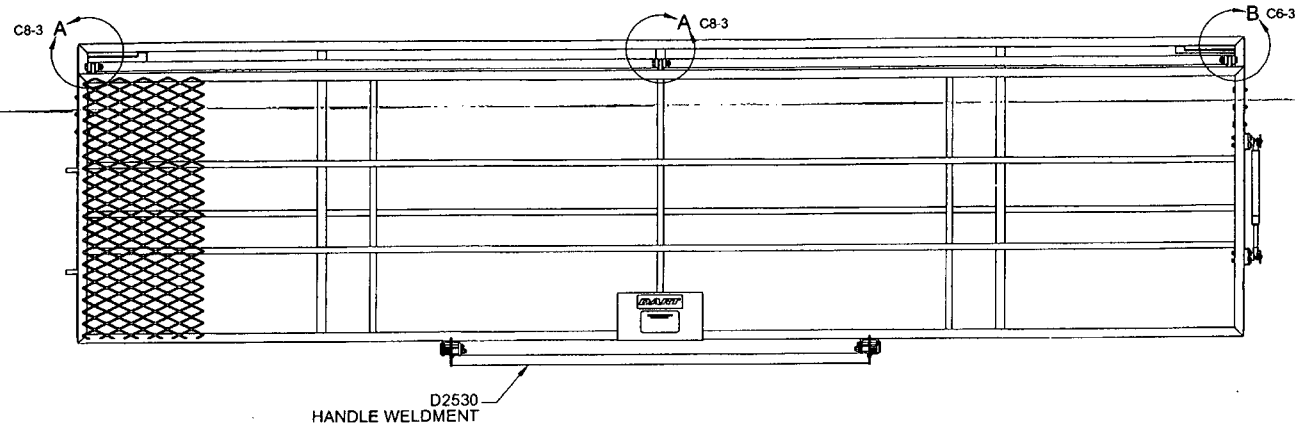
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

82873

RELEASED
10.08.12

DESIGN	AS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	SES	D4030	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350) _____ NTS.	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1

Dart Aerospace Ltd

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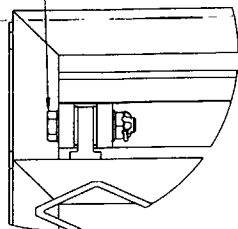
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

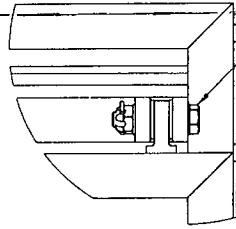
NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



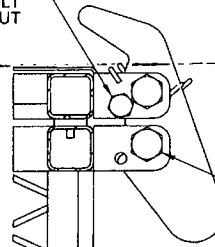
DETAIL A D8-2
D5-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



DETAIL B D3-2

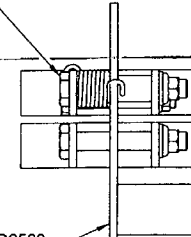
AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT
D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT



D2530
HANDLE WELDMENT
REF

VIEW F-F C3-3

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

82873

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10.08.124

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MFG. APPR.	<i>JFS</i>	D4030	SHEET 3 OF 3
APPROVED	<i>AS</i>	TITLE	SCALE
DE APPR.	<i>AS</i>	LONG BASKET-ASSY (350)	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries